

# Work Order ID 86237

**\*86237\***

Page 1

June-25-12 10:32:29 AM

Item ID: D3537-3

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Wearpad

Stop

**\*NS2\***

Start Date: 25/06/2012 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/25

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3537

Rev C

100

0.00

**\*100\***

FLOW WATER JET

Waterjet

Memo

0.00

24 0 Jm 12-7-4

FLOW CNC Waterjet

1-Cut as per Dwg D3537 Dwg Rev: C Prog Rev: C 2-  
Deburr if necessary

304 . 063

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

24 0 Jm 12-7-4

Quality Control

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

5/26/10

counters  
x24

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item Name: Wearpad

Start Date: 25/06/2012 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> Brake NC Brake NC	NC BRAKE  Memo Deburr if necessary Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326. Identify as D3537-3 Form Joggle as per Dwg D3537 on brake using Jig DT8158	0.00  0.00				<u>24</u>			<i>SB</i> 12/07/12
140 <b>*140*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo Ensure joggle as per dwg D3429	0.00  0.00		<i>5/26/10</i>		<i>Contes</i> <u>24</u>			
150 <b>*150*</b> Large Fab Large Fab Large Fab	Large Fab  Memo Qty Description Batch A/R 2059B Hardcoat M122279 Weld hardcoat as per Dwg D3437	0.00  0.00				<u>24</u>			12-07-11 JBL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*86237\***

Page 3

Item ID: D3537-3

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Wearpad

Stop **\*NS2\***

Start Date: 25/06/2012 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00

**\*160\***

QC

Memo

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00

**\*170\***

QC

Memo

0.00

Quality Control

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

**\*180\***

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

M121279

3200F

900

counts  
720

24X

12/07/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Item Name: Wearpad

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Start Date: 25/06/2012 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

QC3- Inspect Part Finish

0.00

**\*190\***

QC

Memo

0.00

Quality Control

24x 4 12/07/11

200

Identify as per dwg & Stock Location

0.00

**\*200\***

Packaging

Memo

0.00

Packaging

24X 4 MF 12/07/16

210

QC21- Final Inspection - Work Order Release

0.00

**\*210\***

QC

Memo

0.00

Quality Control

12/17/18 MF 12-07-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

June-25-12 10:32:33 AM

Page 1

Work Order ID: 86237

\*86237\*

Parent Item: D3537-3

\*D3537-3\*

Parent Item Name: Wearpad

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

100

sf

1.5746

0.149

3.136842

\*M304S16GA\*

\*\*

3.25 S.F.

Jm 12-7-4

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

1.574633

121889

1.574633

122245

122245

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

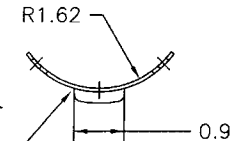
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

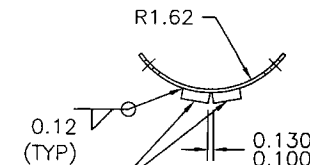
NO 86237

SECTION A-A



APPLY 2 LAYERS OF  
2059B HARDCOAT WELDS  
TO WITHIN 0.25 OF  
WEARPAD ENDS  
0.188 TO 0.250 THICK

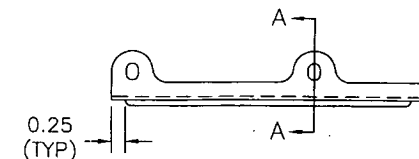
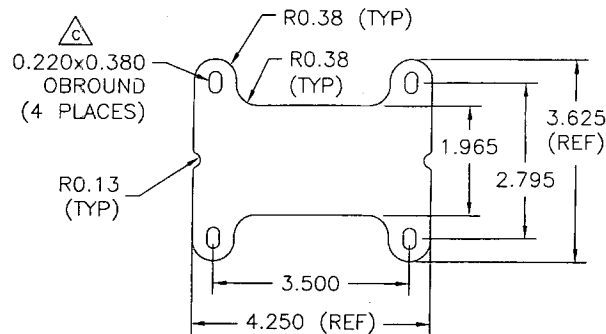
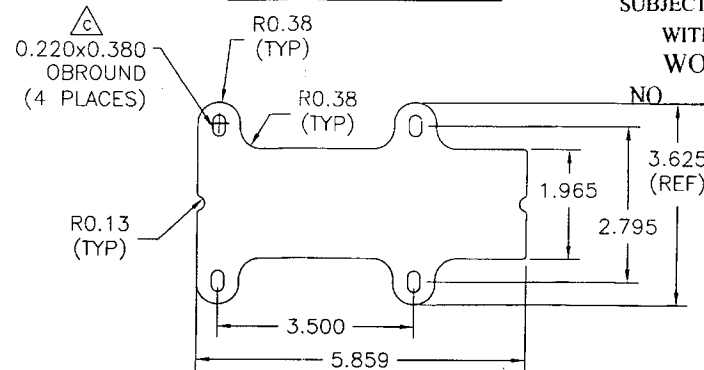
SECTION B-B



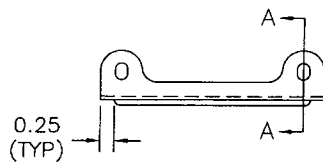
D2941-300  
REMOVE POWDER  
COAT FROM THESE  
SURFACES

**RELEASED**  
07.05.08 AH  
PER ECU  
962

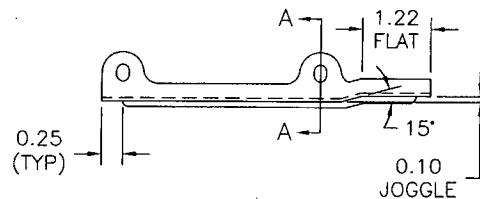
**D3537-7 LONGITUDINAL BEND**  
(MADE FROM D3537-3F)

**D3537-1F FLAT PATTERN****D3537-3F FLAT PATTERN**

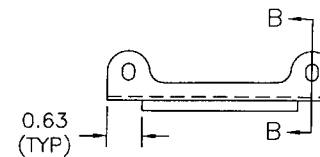
**D3537-1 LONGITUDINAL BEND**  
(MADE FROM D3537-1F)



**D3537-3 LONGITUDINAL BEND**  
(MADE FROM D3537-3F)



**D3537-5 LONGITUDINAL BEND**  
(MADE FROM D3537-1F)

**D3537-1/-3/-5/-7 WEARPAD NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE USA, INC.

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	A	APPROVED A
DATE	07.04.13	TITLE WEARPAD
DRAWING NO.	D3537	SHEET 1 OF 1
SCALE		1:2

**DART AEROSPACE USA, INC.**  
PORT HADLOCK, MA

OK 11/11/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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